Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

Form No.	CNC/QA/FM/02
Rev. No.	01
Rev. Date	31-07-2013

Inprocess Inspection (Pellet Dies)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		10647	35/50
2	Machined By		V.T.L M/C Shop	Dg No. L.S.D. 289 Rev-00
3	Pallet Die No.		11074 (4.0) HH	
4	Die Category	Drg. No.	Extra wide	
5	Out Side Diameter	Drg. No.	620 HH Step OD: 624 HH	Step length = 19.5
6	Inside Diameter	Drg. No.	520.12 HH	Taper 12°
7	Width of Pellet Die	Drg. No.	22 HH	Undercut 2 HH
8	Grooves as per Drawing	Drg. No.	14x8x5 HH / 14x8x5 HH	
9	Fitting Sizes on CNC Plate	Drg. No.	Ok	
10	Drilling Area Surface Smoothness		Ok	
11	Tapping Operator		M/C Shop	Tapping No of Holes 12 Both side
12	Tapping PCD		565 HH	
13	Tapping Hole Diameter		M20 x Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	Ok	
15	Tapping Hole Depth		Drill Depth: 22.7 HH / 21.7 HH	Tapping Depth: 20.8
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		Ok	
	Inspected By (Sign) & Date		Rasi 7/11/23	
1	As per programme no.		———	
2	Gun Drilling Work Completed On		———	
3	Hole Finish In Gun Drilling	Marked	Ok	
4	Defective Holes (If Any)		No	

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

1	Counter Sinking Depth & Finish	Ok						Rev-31
2	External Relief Dia	4.5 HH	Outside (3-3)		Inner			
3	External Relief Depth		18 HH		14 HH			
4	Inspection Done Before Hardening By (Name)		Rasi					
5	Material Sent For Hardening By (Name)		Lark Furnace					
6	Material Sent For Hardening On Date		7	11	23			
	Inspected By (Sign) & Date		Rasi 7/11/23					

Reviewed by (Engineer-CNC) Satya 7/11/23

Manager-QA

Scanned with CamScanner